

split for 2

Dart Aerospace Ltd.

Date: Friday, 15/02/2008 10:46:59 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARING ASSEMBLY
 Job Number : 37475 -2
 Estimate Number : 10716
 P.O. Number :
 This Issue : 15/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 37470
 Part Number : D3121241
 Drawing Number : D3121 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 22/02/2008 Qty: 40 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 04.02.18 New issue KJ/DS
 Est Rev: B ECN 1060 07-11-12 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELINR12500 DELRIN ROUND BAR 1.25"



60

Comment: Qty.: 0.0546 f(s)/Unit Total : 2.1840 f(s)

Material: Ø1.25 Delrin Rod

(M-DELIN-R1.2500) Identify as D3121-25

Batch: M104398

H.A

08/02/16

2.0 HARDINGE HARDINGE CNC LATHE SMALL



60

Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

H.A / MK

08/02/16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



60

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A / MK

08/02/16

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BC 08-02-18

60

5.0 D312123 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing

B36670 x (11mm)

B37476 x (40)

MF 08-02-22 (51)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-02-20	2	take 4 for OE 5461	C	08-02-20	4	C	08-02-26	
2008/2/26	2	PLACE 3 CAPS D 3121-25 IN STOCK AT LOCATION ST066 AND ADJUST STOCK QUANTITY.	W	2008/2/26	3	W	08-02-26	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 15/02/2008 10:46:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 37475

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

MF 08-02-22

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-02-22 (51)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST Q38

AS 08/02/22

(X51)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/25

Job Completion



mi 2008/2/25

(51)
(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

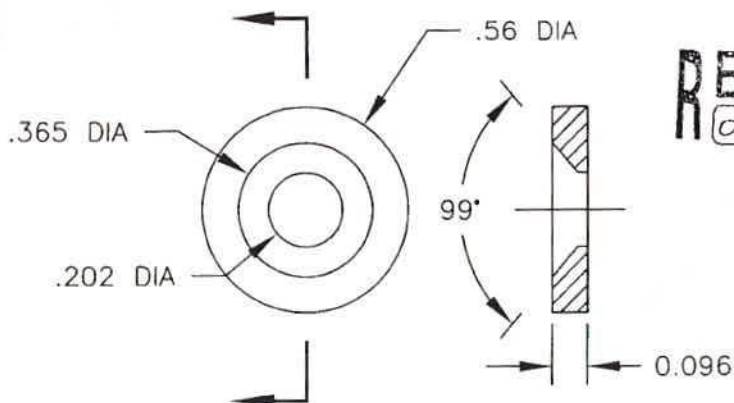
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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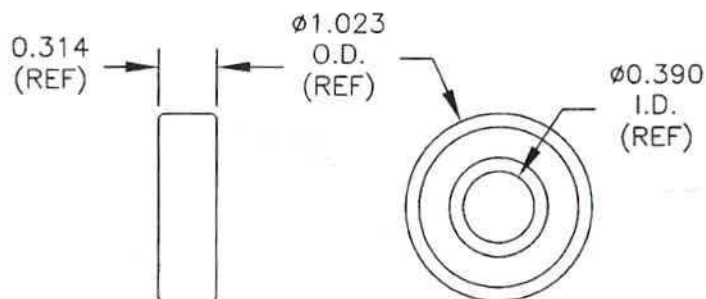
NOTE: Date & initial all entries

DART

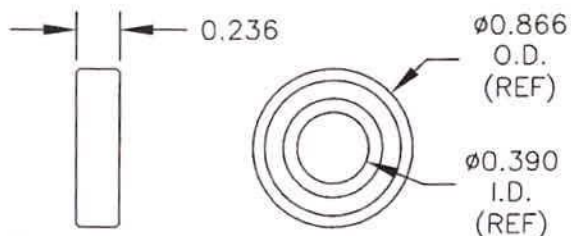
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

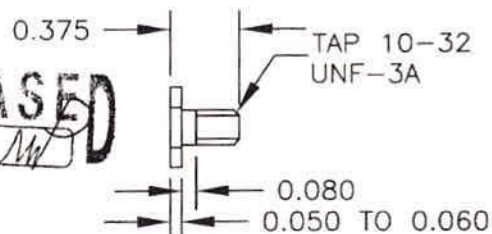
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

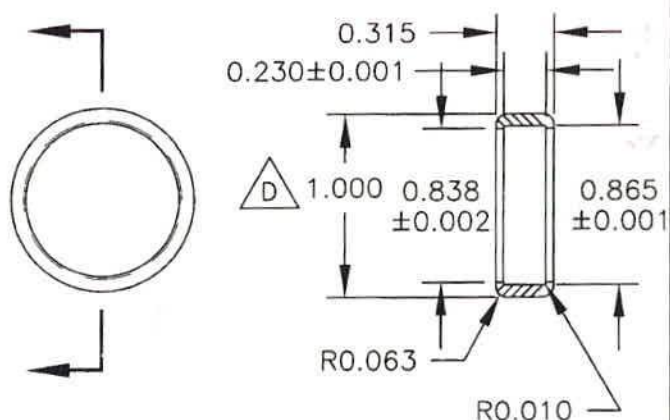
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

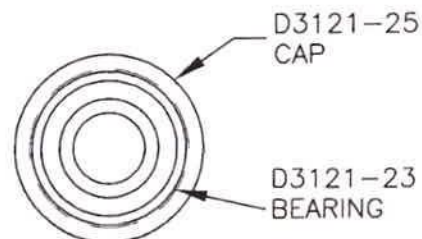
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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